

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027697**Date Inspected:** 01-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** William Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

**OBG East drop-in Splice E13-E14**

QAI performed Magnetic Particle Testing (MPT) on 10% of the QC tested area on weld E13-E14-A1, and E13-E14-A2.1. This QAI used Parker Contour Probe Model B300 bearing serial number 19882, with a calibration date of 5/10/12. Testing was performed from the top and bottom of the deck plate/weld. No rejectable indications noted.

**OBG Suspender Brackets**

This QAI observed the fitting of stiffeners X464-12B on Suspender Bracket PPE-104E. The fitting was performed per unapproved drawing FW464-01 dated 5/29/12 by Eric Sparks. No out of tolerance gaps were noted, stiffeners fit tight to the web and flange.

QAI observed the welding of stiffeners x464-12B on the east side of Suspender Bracket PPE-104E. The welding was being performed by Eric Sparks in the 3G and 4G position using the Shield Metal Arc Welding (SMAW) Process at 126 amps using an E7018H4R consumable electrode.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

QC William Sherwood was observed by this QAI performing in-process weld inspection and QC verification using the applicable Welding Procedure Specification. This QAI observed and verified the welding and QC inspection at random intervals.

The copy of the drawing FW464-01 dated 5/29/12 covering the additional stiffeners on Suspender Bracket 104 and 106 does not contain an Engineers approval stamp. The situation is being investigated by this QAI's superiors.

### W13-W14 Drop-In

This QAI observed the welding of the back gouged backside of weld joint 13W-14W-A2.2. The welding was being performed by Michael Jiminez in the 4G position using the Shield Metal Arc Welding (SMAW) Process at 124 amps using an E7018H4R consumable electrode.

QC William Sherwood was observed by this QAI performing in-process weld inspection and QC verification using the applicable Welding Procedure Specification. This QAI observed and verified the welding and QC inspection at random intervals.

### Summary of Conversations:

There were general conversations with Quality Control Inspector William Sherwood, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Daggett,Matt	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

---